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### Amendments to Claims

1. ~~(Currently Amended) A process for manufacturing a multilayer container having a transparent outer layer around the periphery of the container, wherein the outer layer comprises a clear thermoplastic polymer material is transparent in the solid state, and at least one other inner layer, the process comprising the steps: (1) heating each of at least two thermoplastic polymers to a temperature above the melt temperature of each to obtain a homogeneous melt of each of the at least two polymers; (2) co-extruding the at least two thermoplastic polymers through a co-extrusion blow molding head into an open mold; (3) using an extrusion blow molding machine to blow mold the at least two thermoplastic polymeric materials to form a blow molded structure having an internal (inside) surface and an external (outside) surface, wherein the blow molding machine comprises (i) a first head for extruding a first thermoplastic polymer that is to be used as the outer layer, and at least a second head for extruding at least one additional polymer wherein at least the first head has been modified to extrude a homogeneous melt of the first thermoplastic polymer; (ii) (a) a mold comprising a first cooling means for cooling the outside of the blow molded structure and (b) a second cooling means for cooling the inside of the blow molded structure as it is blow molded; (iii) a pinch-off area and a dual pinching means for pinching the outer layer in a manner such that the outer layer forces the at least one other layer out of the pinch-off area; and, (5) using the first and second cooling means to cool the inside and outside of the blow molded structure to a temperature below about 22°C, while forming the blow molded structure. A process for manufacturing a multilayer container having a transparent outer layer comprising a first thermoplastic polymer that is transparent in the solid state and at least one inner layer comprising a second thermoplastic polymer, said process comprising the steps of:~~
- (1) heating and co-extruding the first and second thermoplastic polymer to obtain a first and second polymer melt, respectively, wherein at least the first polymer melt is gel-free and homogeneous;

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(2) passing the co-extruded polymer melts through a blow molding die to form a multilayer parison having an outer layer formed of the first polymer melt, at least one inner layer formed of the second polymer melt, and an inner cavity;

(3) depositing the parison into an open mold;

(4) closing the mold and pinching off the parison at one end in a manner such that the outer layer of the parison is continuous at the pinched point to form a molded parison; and

(5) obtaining the multilayer container by inflating the molded parison into a blow molded structure while simultaneously cooling the blow molded structure to a temperature below about 22°C by applying a first cooling means to the outside of the blow molded structure and a second cooling means to the inside of the blow molded structure.

2. (Currently Amended) The process of Claim 1 wherein only a the first and a the second thermoplastic polymers are extruded in the process.

3. (Currently Amended) The process of Claim 2 1 wherein the ~~second head has been modified to extrude a homogeneous melt of the~~ second polymer melt obtained from step (1) is gel-free and homogeneous.

4. (Currently Amended) The process of Claim 3 1 wherein the first cooling means is a cooling system that maintains the a mold maintained at a temperature of less than 20 °C, and the second cooling means is comprises a means for discharging a cold gas under pressure into the inner cavity of the parison during the inflation of the molded parison in step (5).

5. (Original) The process of Claim 4 wherein the cold gas is discharged at a temperature of less than about 20°C.

6. (Original) The process of Claim 5 wherein the cold gas is discharged at a temperature of less than about 18 °C.

7. (Original) The process of Claim 6 wherein the cold gas is discharged at a temperature of less than about 15 °C.

8. (Original) The process of Claim 7 wherein the cold gas is discharged at a temperature of less than about 5 °C.

9. (Currently Amended) The process of Claim 8 1 wherein the first thermoplastic polymer is a polymer selected from the group consisting of: polyurethanes; acrylic



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polymers; styrene acrylonitrile (SAN) copolymers; copolymers of ethylene and alpha, beta-unsaturated carboxylic acids; and/or their derivatives of copolymers of ethylene and alpha, beta-unsaturated carboxylic acids; polyamides; and polyvinyl chlorides.

10. (Currently Amended) The process of Claim 9 wherein the first thermoplastic polymer is a copolymer of ethylene and an unsaturated carboxylic acid.

11. (Currently Amended) The process of Claim 10 wherein the first thermoplastic polymer is an ionomer that is a derivative of a copolymer of ethylene and an alpha, beta-unsaturated carboxylic acid.

12. (Currently Amended) The process of Claim 4 11 wherein ~~the process additionally comprises the step of: using the pinching means to pinch off the blow molded structure and obtain a blow molded structure having a continuous transparent outer layer around the periphery of the article wherein the pinched point is flat or at tapered at least slightly toward the inner cavity of the blow molded structure, and wherein the mold surface is roughened, not polished in step (4), the parison is pinched off by a dual pinching means and the pinched point is flat or tapered at least slightly toward the inner cavity of the blow molded structure.~~

13-28. (Canceled)

29. (Currently Amended) ~~A process for manufacturing a multilayer container having a transparent outer layer around the periphery of the container, wherein the outer layer comprises a clear thermoplastic polymer material that is transparent in the solid state, and at least one other inner layer, the process comprising the steps: (1) heating each of at least two thermoplastic polymers to a temperature above the melt temperature of each to obtain a homogeneous melt of each of the at least two polymers; (2) co-extruding the at least two thermoplastic polymers through a co-extrusion blow molding head into an open mold; (3) using an extrusion blow molding machine to blow mold the at least two thermoplastic polymeric materials to form a blow molded structure having an internal (inside) surface and an external (outside) surface, wherein the blow molding machine comprises: (i) a first head for extruding a first thermoplastic polymer that is to be used as the outer layer, and at least a second head for extruding at least one additional polymer wherein at least the first head has been modified to extrude a homogeneous melt of the first thermoplastic polymer; (ii) (a) a mold comprising a first cooling means for cooling the outside of the blow molded~~

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~~structure and (b) a second cooling means for cooling the inside of the blow molded structure as it is blow molded; (iii) a pinch off area and a dual pinching means for pinching the outer layer in a manner such that the outer layer forces the at least one other layer out of the pinch off area; (4) blow molding the polymers (parison) to form a multilayer blow molded structure; and, (5) using the first and second cooling means to cool the inside and outside of the blow molded structure to a temperature below about 22°C, while forming the blow molded structure, wherein the mold has a surface that is roughened and not polished. The process of claim 1, wherein the inner surface of the mold comprises surface imperfections.~~

30. (Canceled)

31. (New) The process of claim 4, wherein the second cooling means further comprises a means for allowing escape of gas from the inside of the blow molded structure.

32. (New) The process of claim 4, wherein the second cooling means is a blow-pin, which comprises a nozzle that fits into the opening of the parison cavity and discharges the cold gas into the inner cavity of the parison under pressure.

33. (New) The process of claim 32, wherein the blow-pin is covered by a cooling jacket over at least 95% of the blow-pin surface, not inclusive of the nozzle.

34. (New) The process of claim 33, wherein the blow-pin further comprises a channel which is cut into the nozzle, thereby further providing the means for allowing the escape of gas from the inside of the blow molded structure.

35. (New) The process of claim 33, wherein the nozzle of the blow-pin has a rough surface, thereby further providing the means for allowing the escape of gas from the inside of the blow molded structure.